

Work Order ID 82239***82239***

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Tuesday, March 27, 2012 2:39:09 PM

Item ID: D4055-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 3/27/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/20/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: ME Date: 12-03-27 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4055	C

100 Weld per dwg A/R Aluminum rod Batch: 119785 0.00
120169

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11
as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure
doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg,
locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

12.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D4055-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 3/27/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part completeness to step on W/O	0.00							
123									
QC	Memo	0.00							
Quality Control	***Pressure Test as per dwg D4055***								
	TESTED IAW QS1038 12-4-12								
130	Chemical Conversion Coat per QS1005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing	1- brush alodine on tank. No alodine inside								
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 12/4/12/12/4/12
 m-p
 12/10/12

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Powdercoat Powder Coating M118533	Gloss Grey (4.3.5.15) per QSI 005 4.3 Memo ***Mask prior to powdercoat*** Start Time: 10:30 Oven Temperature: 320°F Finish Time: 11:00	0.00 0.00				1X	✓		M-L 12/04/18
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	✓		BL 124-18.
190 *190* Small Fab Small Fab	Assemble as per dwg & DSI 9577 Memo	0.00 0.00				1X	✓		fb 12/04/18 12/04/18

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N900040100Setup Start ***NS1***

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Start Date: 3/27/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 1.00

1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

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220 QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

230 Identify as per dwg & Stock Location: _____

0.00

230

Packaging

Memo

0.00

Packaging

240 QC21- Final Inspection - Work Order Release

0.00

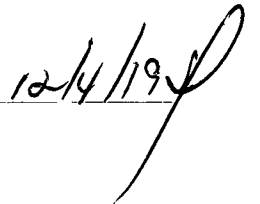
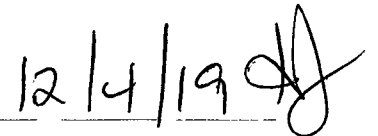
240

QC

Memo

0.00

Quality Control

12/4/19 12/4/19 

12-04-19

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Parent Item Name: Fuel Tank Assembly

Start Date: 3/27/2012 Required Date: 4/20/2012
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B 10.05.17 ECN10-562
DD verf:EC IPP Rev C: 10.11.23 revised pick list EC verified by:DD
IPP Rev D: 11.06.01 per D4055 revB EC verified by:DD IPP Rev:E 12.02.27 per D4055
revC DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No			190	Each	10.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		10							
				80847		10				80847			
D3997-5 Placard		Manufactured	No			190	Each	9.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		99							
				72611		89				72611			
				81028		10							
D3997-11 Placard		Manufactured	No			190	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		6							
				80308		6				80308			
D3997-17 Placard		Manufactured	No			190	Each	8.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		8							
				80309		8				80309			
D3997-29 Placard		Manufactured	No			190	Each	21.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		21							
				80845		21				80845			

12/04/18

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 Parent Item Name: Fuel Tank Assembly

Start Date: 3/27/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-43	Manufactured	No	190	Each	6.0000	1	1	<i>YB 12/04/18</i>
Placard								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST141	6				
			80310	6				<u>80310</u>
✓ D3999-7	Manufactured	No	100	Each	11.0000	1	1	<i>12.04.05</i>
Corner								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA014	11				
			71695	1				
			75156	10				
✓ D3999-9	Manufactured	No	100	Each	2.0000	1	1	<i>12.04.10</i>
Angle								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA014 <u>382545</u>	2				
			71696	2				
✓ D3999-11	Manufactured	No	100	Each	4.0000	1	1	<i>12.04.04</i>
Earth Tab								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	8				
			WA013	-8				
			WA014	4				
			75180	4				
✓ D3999-041	Manufactured	No	100	Each	5.0000	1	1	<i>12.04.04</i>
Baffle Assembly, Aft								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	4				
			80027	4				
			WA014	1				
			75230	1				

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Work Order ID: 82239

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Parent Item Name: Fuel Tank Assembly

Start Date: 3/27/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3999-043	Manufactured	No	100	Each	6.0000	1	1	<i>12.04.04</i>
Baffle Assembly, Fwd								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA	6					
		78814	2					
		80028	4					
D4000-1	Manufactured	No	100	Each	3.0000	1	1	<i>12.04.04</i>
✓ Fuel Supply Fitting								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA	3					
		80029	3					
✓ D4000-5	Manufactured	No	100	Each	3.0000	1	1	<i>12.04.04</i>
Fuel Tank Vent Fitting								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA013	3					
		80030	3					
✓ D4000-9	Manufactured	No	100	Each	12.0000	3	3	<i>12.04.04</i>
Grommet								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA013	12					
		78379	12					
✓ D4000-043	Manufactured	No	100	Each	6.0000	1	1	<i>12.04.04</i>
Drain Fitting Assembly, Fwd								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA	6					
		78732	1					
		80035	5					

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Work Order ID: 82239

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Parent Item Name: Fuel Tank Assembly

Start Date: 3/27/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00



D4000-045
Fuel Pickup Fitting Assembly

Manufactured No

100 Each 4.0000

1 1

12.04.11

Location	Loc Qty	Loc Code
WA <i>382696</i>	2	
81071	2	
WA013	1	
72078	1	
WA014	1	
71669	1	

1



D4000-041
Drain Fitting Assembly, Aft

Manufactured No

100 Each 5.0000

1 1

12.04.04

Location	Loc Qty	Loc Code
WA	5	
81070	5	

1



D4001-1
Fitting

Manufactured No

100 Each 5.0000

1 1

12.04.04

Location	Loc Qty	Loc Code
WA014	5	
80031	5	

1



D4008-11
Hinge Half

Manufactured No

100 Each 14.0000

1 1

12.04.04

Location	Loc Qty	Loc Code
WA	14	
80037	6	
80838	8	

1



D4008-041
Fuel Filler Splash Guard Assembly

Manufactured No

190 Each 5.0000

1 1

78910 12/04/18

Location	Loc Qty	Loc Code
ST142	5	
72792	1	
78910	4	

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Start Date: 3/27/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3 Manufactured No 100 Each 6.0000 1 1

Cap and Flange

12.04.04

Location Loc Qty Loc Code

ST110 2

73514 2

WA 4

80032 4

D4025-1 Manufactured No 100 Each 4.0000 1 1

Fuel Quantity Sender

JB 12/04/18

Location Loc Qty Loc Code

ST143 4

71765 1

80033 3

D4055-11 Manufactured No 100 Each 5.0000 1 1

Tank Front and Bottom

80033 12.04.04

Location Loc Qty Loc Code

WA 4

80046 4

WA014 1

74908 1

D4055-9 Manufactured No 100 Each 4.0000 1 1

Tank Back

12.04.04

Location Loc Qty Loc Code

WA 4

80045 4

D4055-7 Manufactured No 100 Each 7.0000 1 1

Tank Fwd End

12.04.04

Location Loc Qty Loc Code

WA 7

73441 1

78813 6

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Start Qty: 1.00

Required Qty: 1.00

D4055-5 Tank Upper Cut Out Manufactured No 100 Each 9.0000

1 1 *12.04.04*

Location Loc Qty Loc Code

WA 4
80047 4
WA014 5
74907 5

D4055-3 Tank Aft End Manufactured No 100 Each 6.0000

1 1 *12.04.05*

Location Loc Qty Loc Code

WA 4
80044 4
WA014 2
75224 2

D4055-1 Tank Top Manufactured No 100 Each 4.0000

1 1 *12.04.04*

Location Loc Qty Loc Code

WA013 4
78820 4

D4057-1 Retaining Ring Manufactured No 100 Each 8.0000

3 3 *12.04.04*

Location Loc Qty Loc Code

WA013 *381889* 8
71166 8

AN3H5A Bolt Purchased No 190 Each 57.0000

5 5 *JB 12/04/18*

Location Loc Qty Loc Code

ST351 57
118112 1
120498 6
120693 50

1x120498
4x120693

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Start Date: 3/27/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

1,204.0000

5

Washer

Location

Loc Qty

Loc Code

ST298

1204

117601

61

118077

1

118612

18

119537

33

120142

127

120308

46

120644

910

120986

8

121243⁵

✓ JB

D4404-1

Manufactured

No

190

Each

4.0000

1

1

Cushion

Location

Loc Qty

Loc Code

ST242A

4

75181

4

75181

✓

D4404-5

Manufactured

No

190

Each

12.0000

1

1

Cushion, Fwd

Location

Loc Qty

Loc Code

ST242A

12

76899

2

80753

10

80753

✓

D4404-7

Manufactured

No

190

Each

8.0000

1

1

Cushion, Upper Side

Location

Loc Qty

Loc Code

ST242A

8

79119

4

80754

4

80754

JB

12/04/18

W/O:		WORK ORDER CHANGES					
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Start Date: 3/27/2012

Required Date: 4/20/2012

Parent Item Name: Fuel Tank Assembly

Start Qty: 1.00

Required Qty: 1.00

D4404-9
Cushion, Lower Side

Manufactured No

190 Each 8.0000

1

1

✓ JB 3/27/12

Location

Loc Qty

Loc Code

ST

-4

79120

4

ST242B

12

80755

4

80755

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

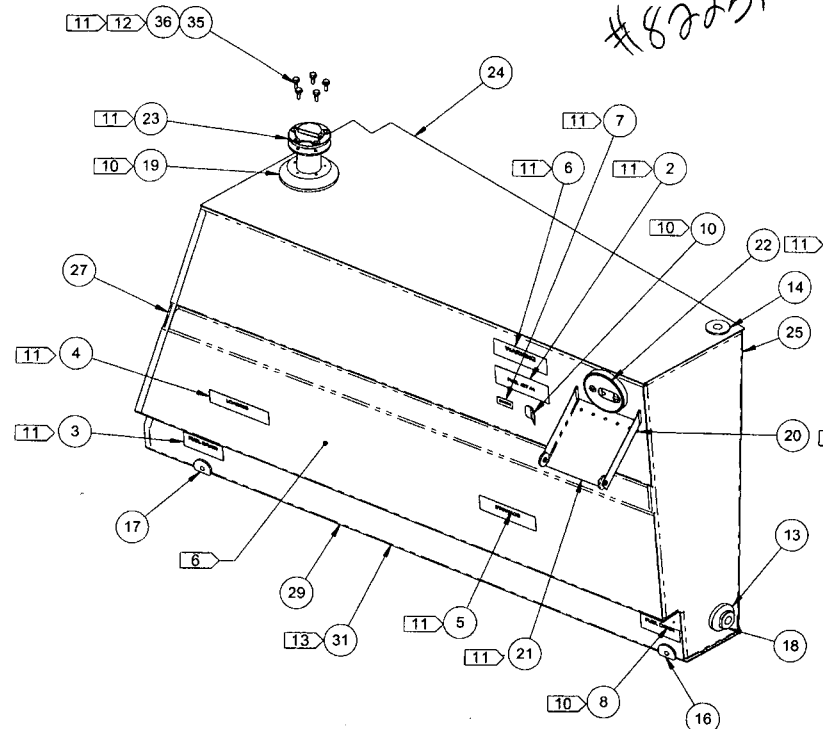
NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	1	D4404-5	CUSHION, FWD
33	1	D4404-7	CUSHION, UPPER SIDE
34	1	D4404-9	CUSHION, LOWER SIDE
35	5	AN3H5A	BOLT
36	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY



C	ADDED ITEMS 32, 33, 34, ZONE B8-1, ADDED NOTE 8, ZONE A8-1, CHANGED POWDER COAT FROM "GREY SANDEX" TO "ANSI 61 GREY", ZN A8-1, DELETED INSTRUCTIONS FOR SLOSHING COMPOUND, ZN A8-3.	DC	12.01.20
B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4055 TANK COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.01.20	REV. C SHEET 1 OF 15 SCALE NTS	

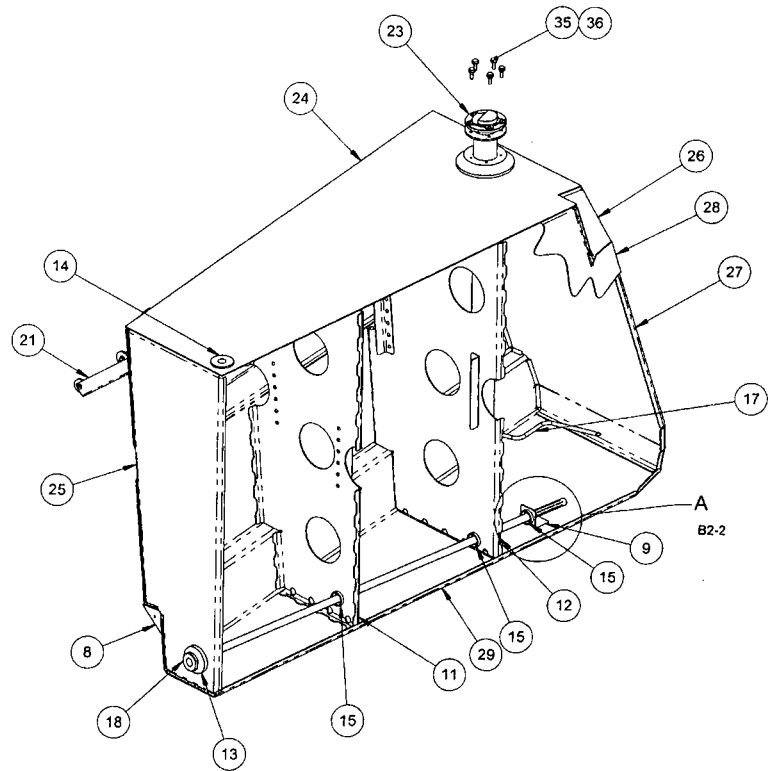
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

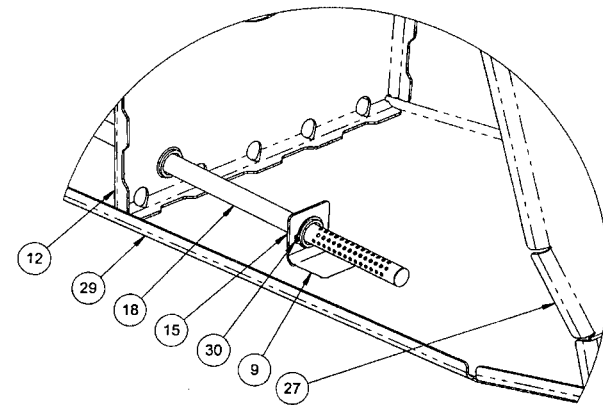
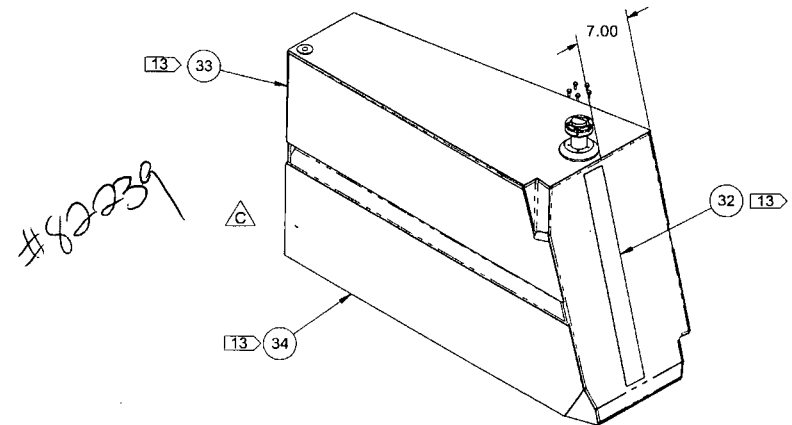
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

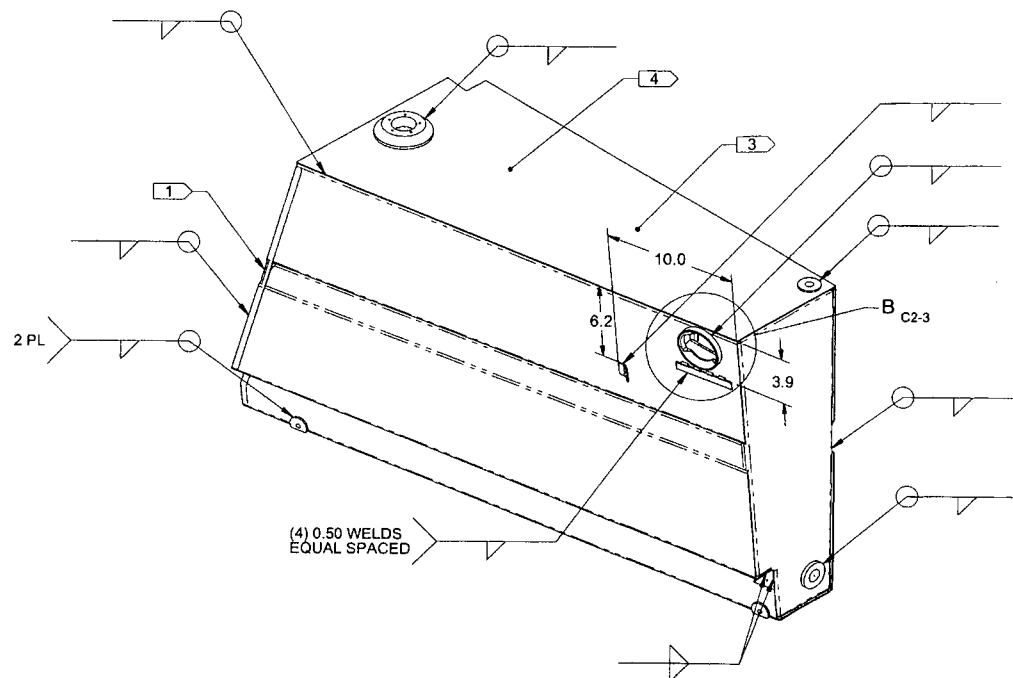


DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

RELEASED
 2012-02-27

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4055	SHEET 2 OF 15
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	TANK	NTS
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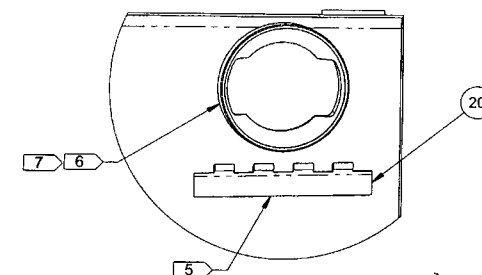


(4) 0.50 WELDS
EQUAL SPACED

D4055-041 FUEL TANK ASSEMBLY WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWARF REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

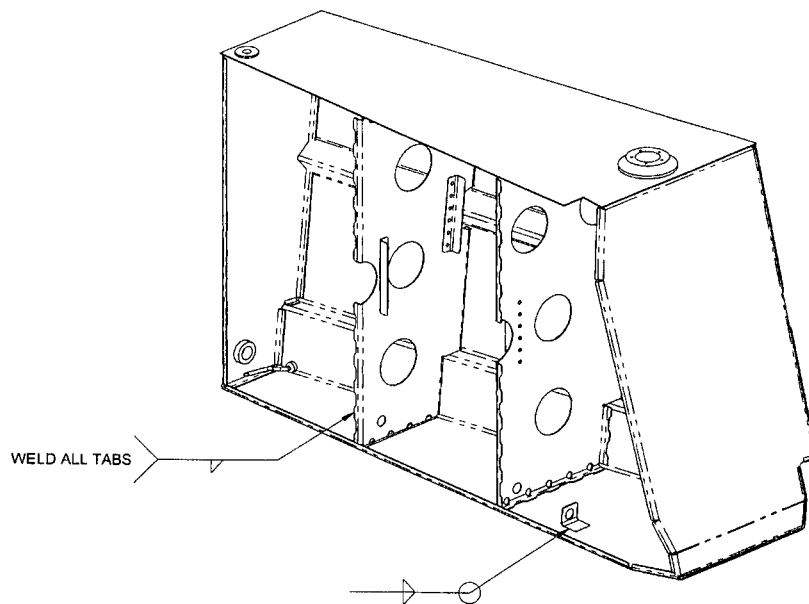


**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

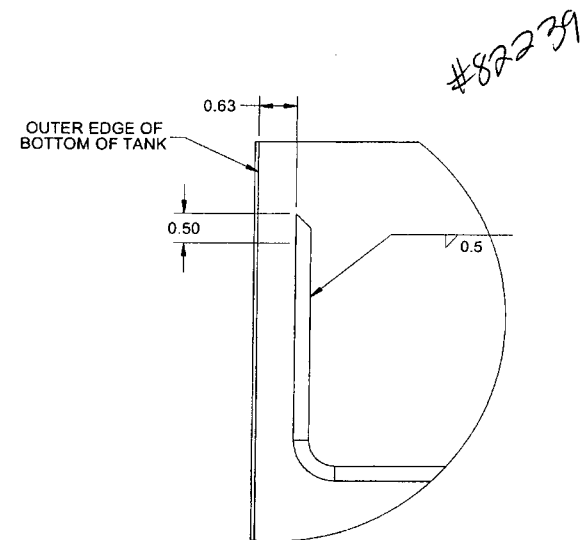
C4-3

RELEASED
2012-02-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4055	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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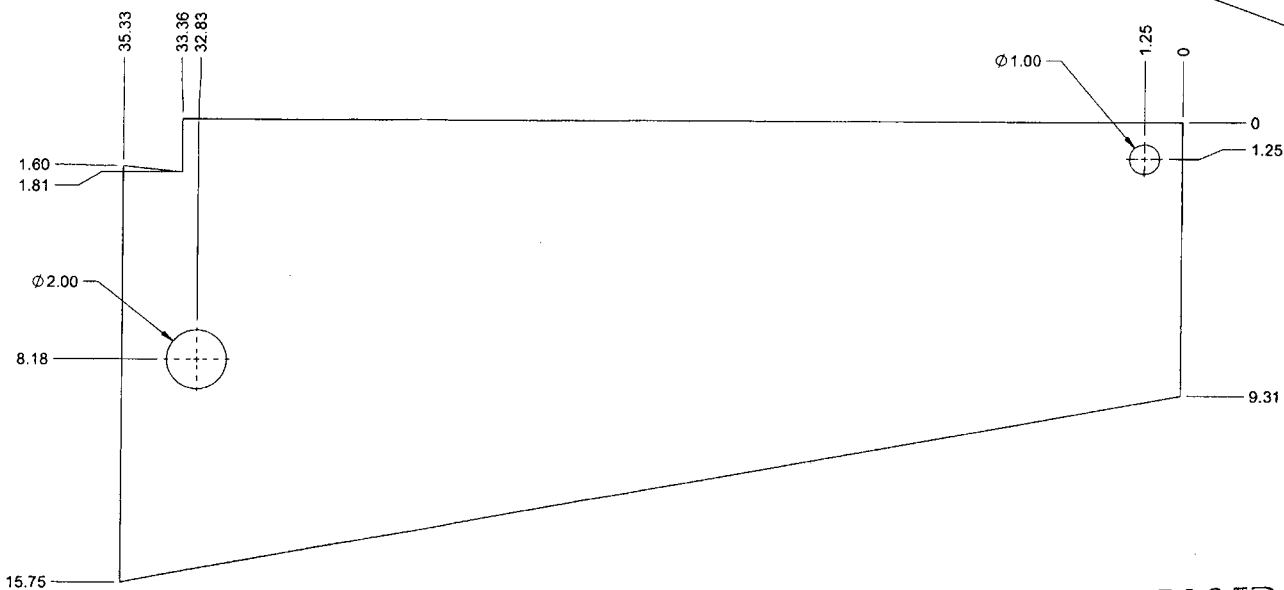


**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**



RELEASED
2012-02-27
AM

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4055	REV. C
MFG. APPR.	BC	SHEET 4 OF 15	
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK	NTS
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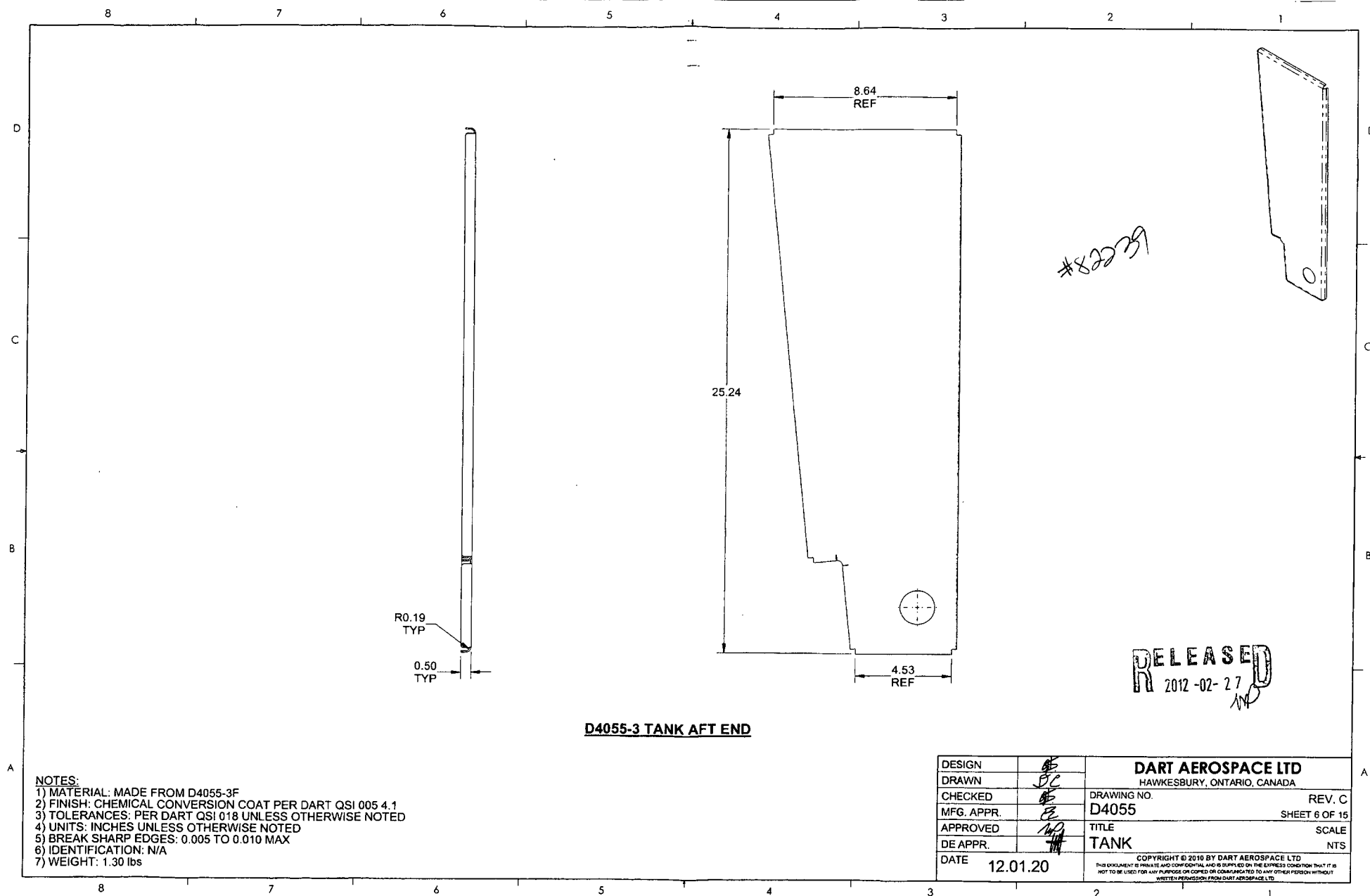
D4055-1 TANK TOP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D4055	SHEET 5 OF 15
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK	NTS
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2012-02-27
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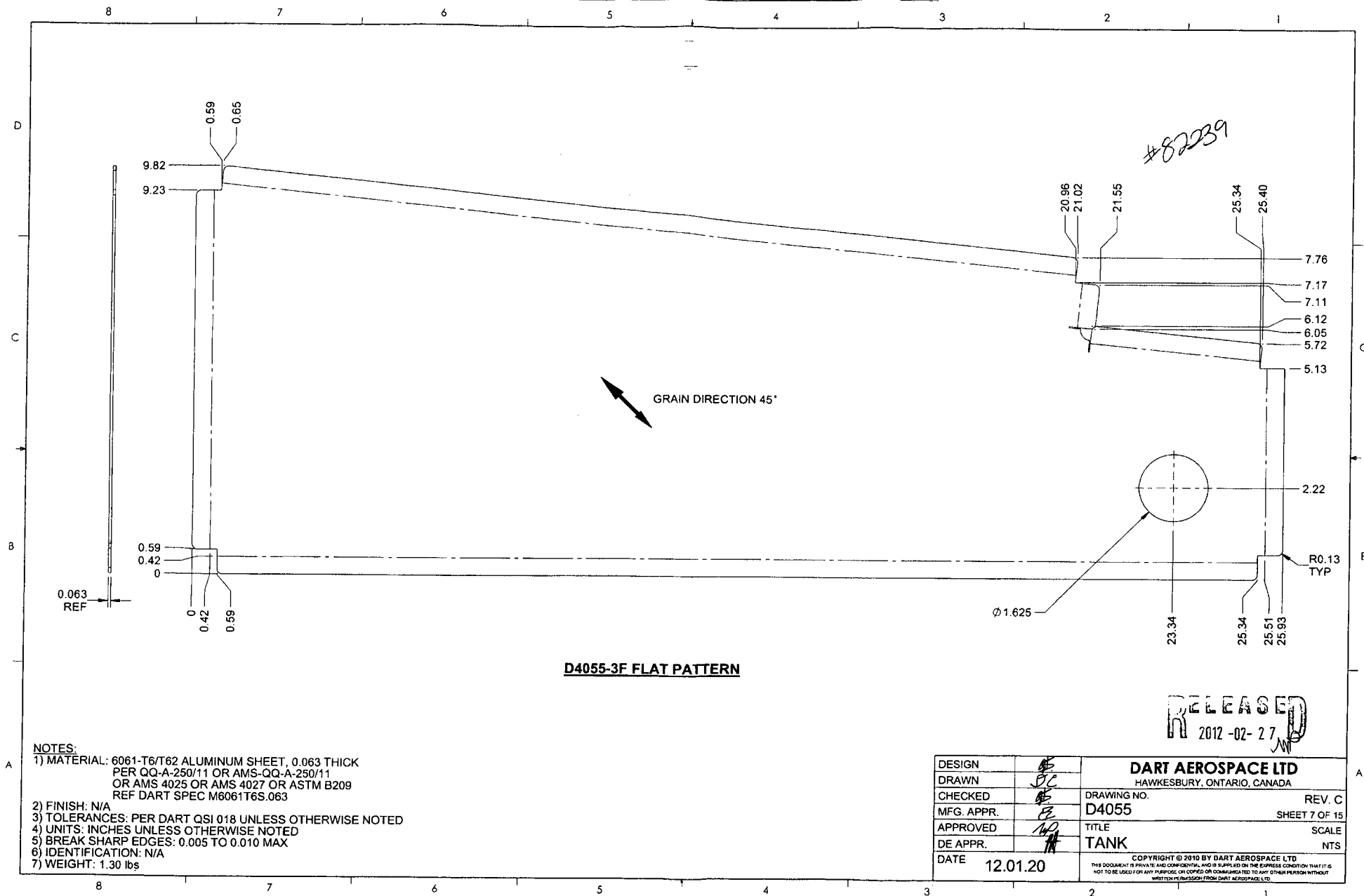


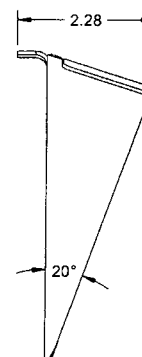
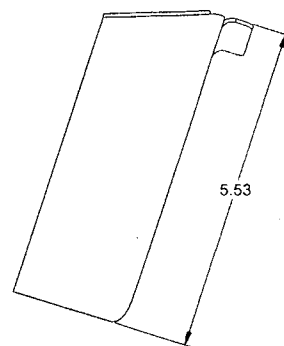
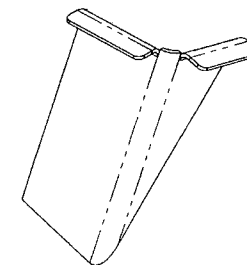
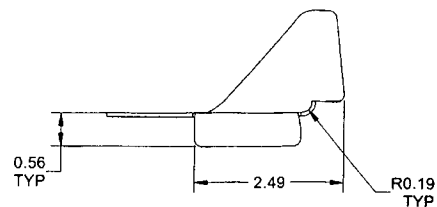
NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN	<i>BE</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BE</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	D4055	SHEET 6 OF 15
APPROVED	<i>BE</i>	TITLE	SCALE
DE APPR.	<i>BE</i>	TANK	NTS
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2012-02-27





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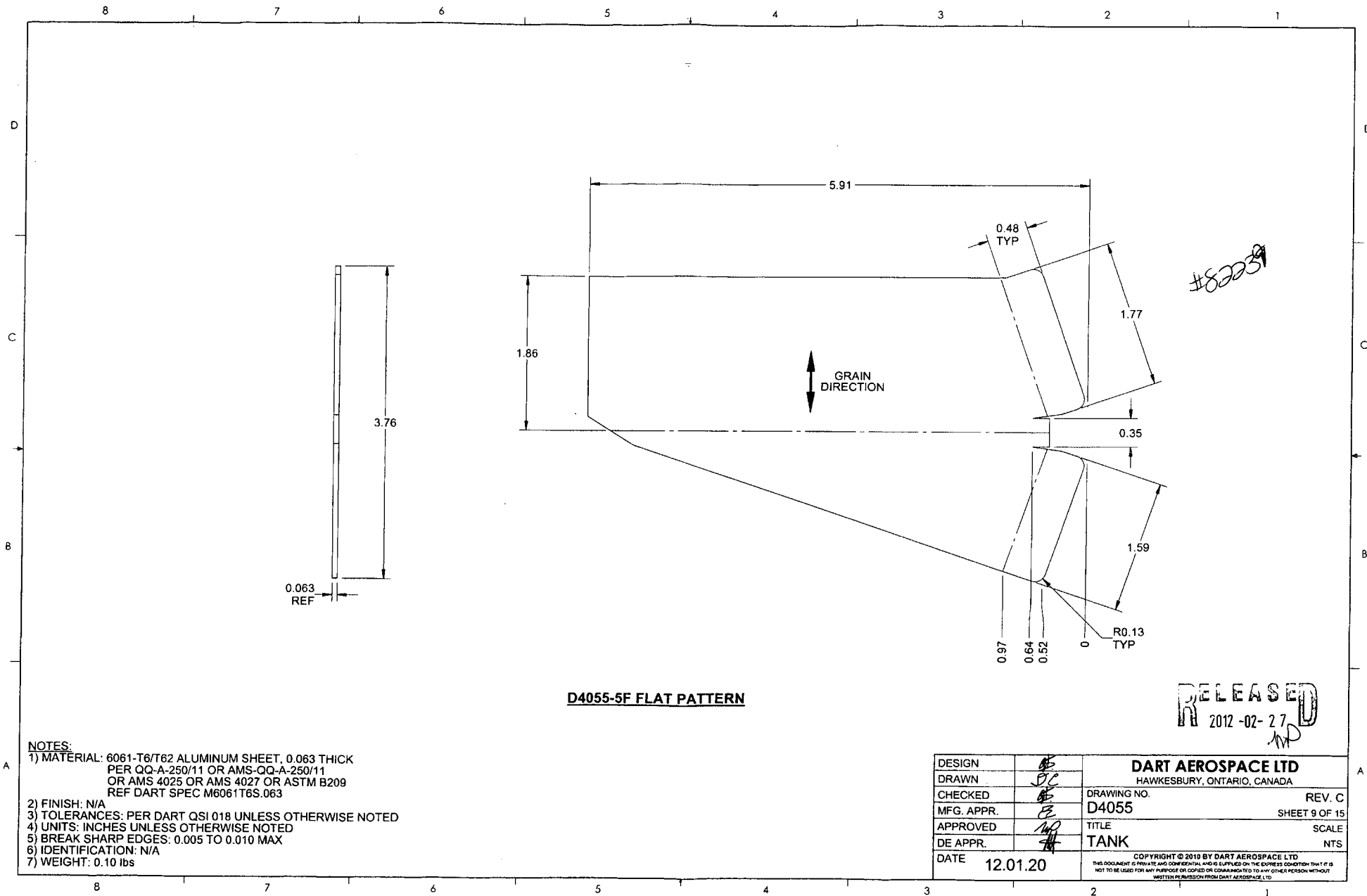
D4055-5 UPPER CUT OUT

RELEASED
R 2012-02-27
MD

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. C
MFG. APPR.	DE	D4055	SHEET 8 OF 15
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	TANK	NTS
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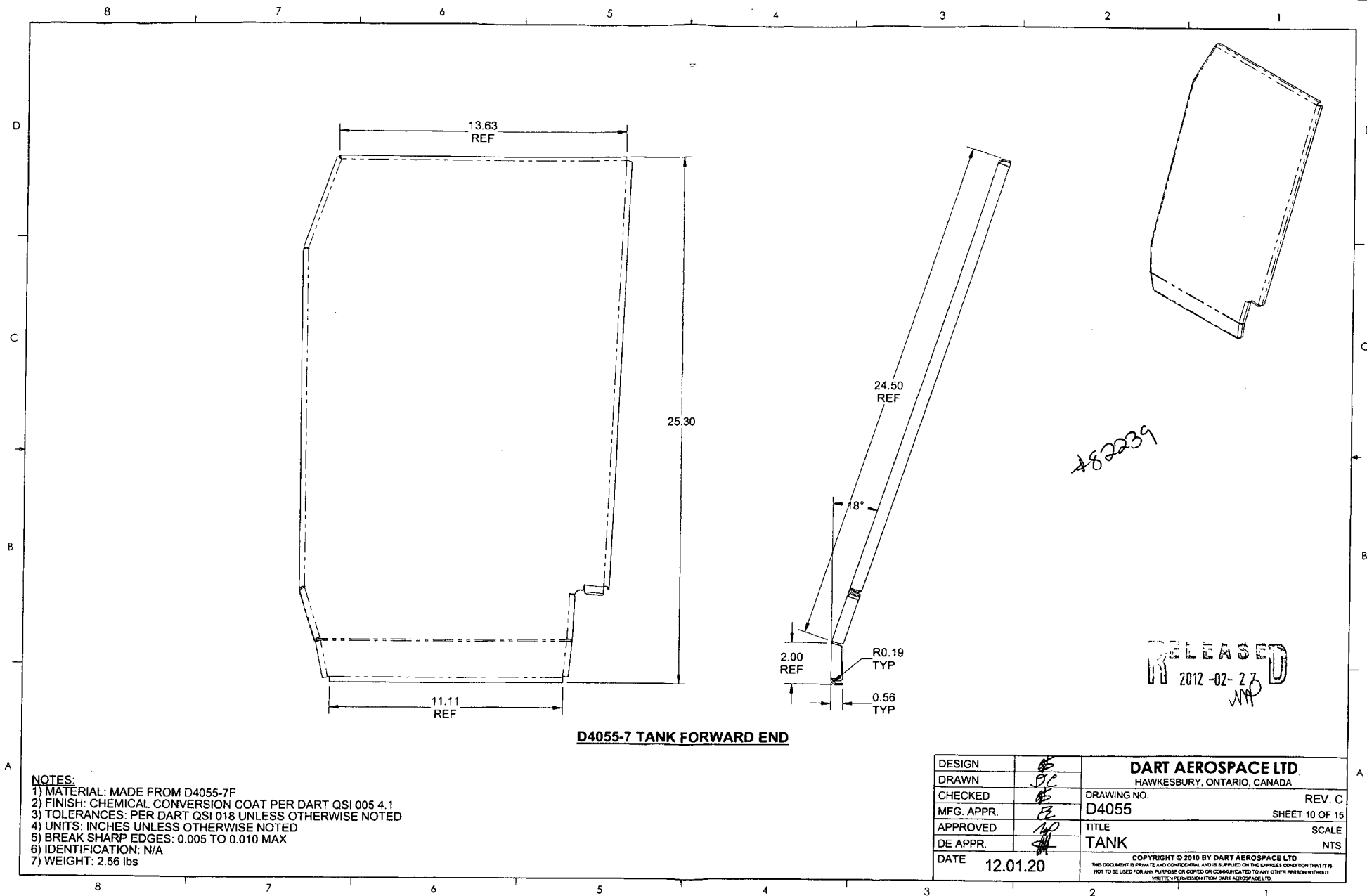


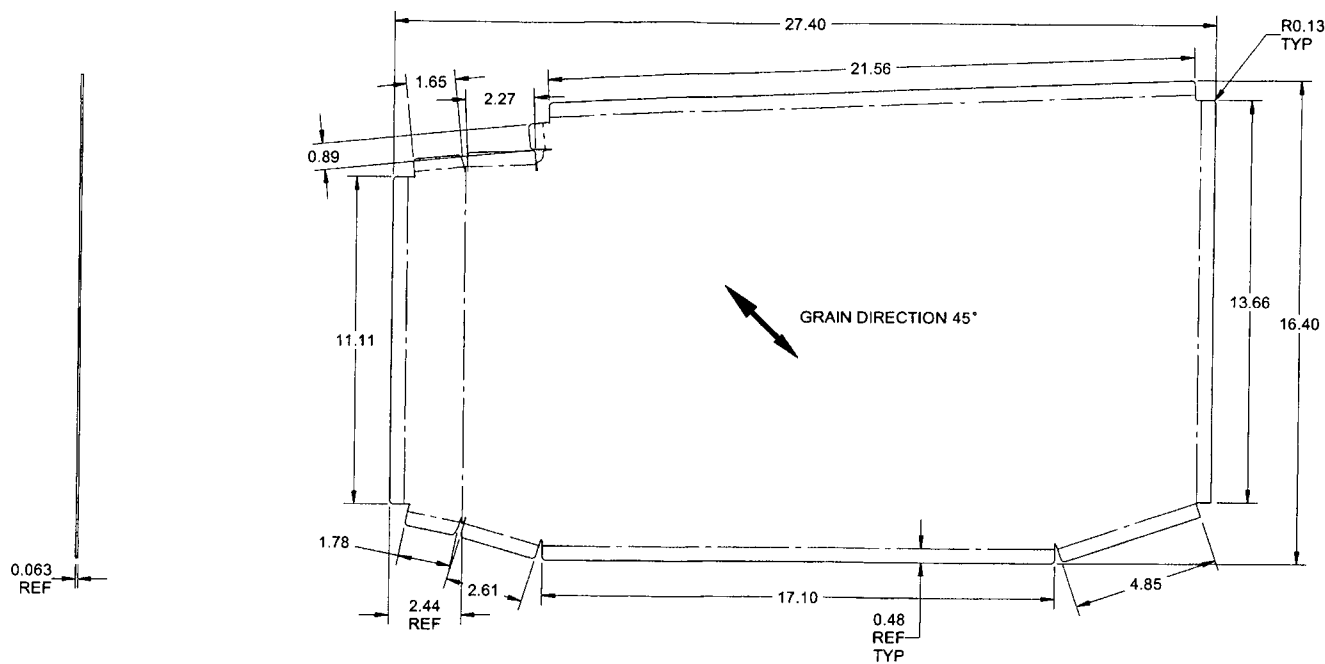
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D4055	SHEET 9 OF 15
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK	NTS
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2012-02-27
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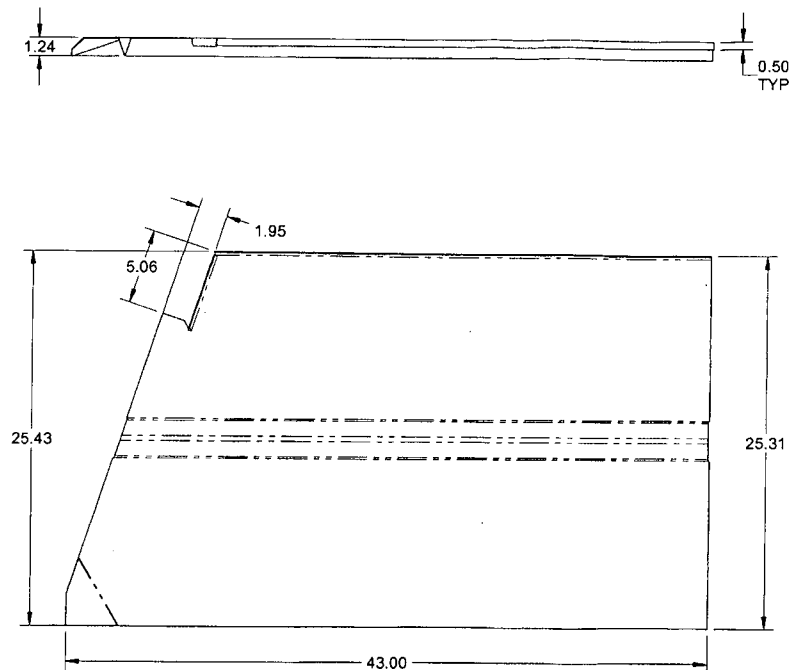
D4055-7F FLAT PATTERN

RELEASED
2012-02-27

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN	<i>ES</i>	DART AEROSPACE LTD	
DRAWN	<i>JC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ES</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JE</i>	D4055	SHEET 11 OF 15
APPROVED	<i>40</i>	TITLE	SCALE
DE APPR.	<i>41</i>	TANK	NTS
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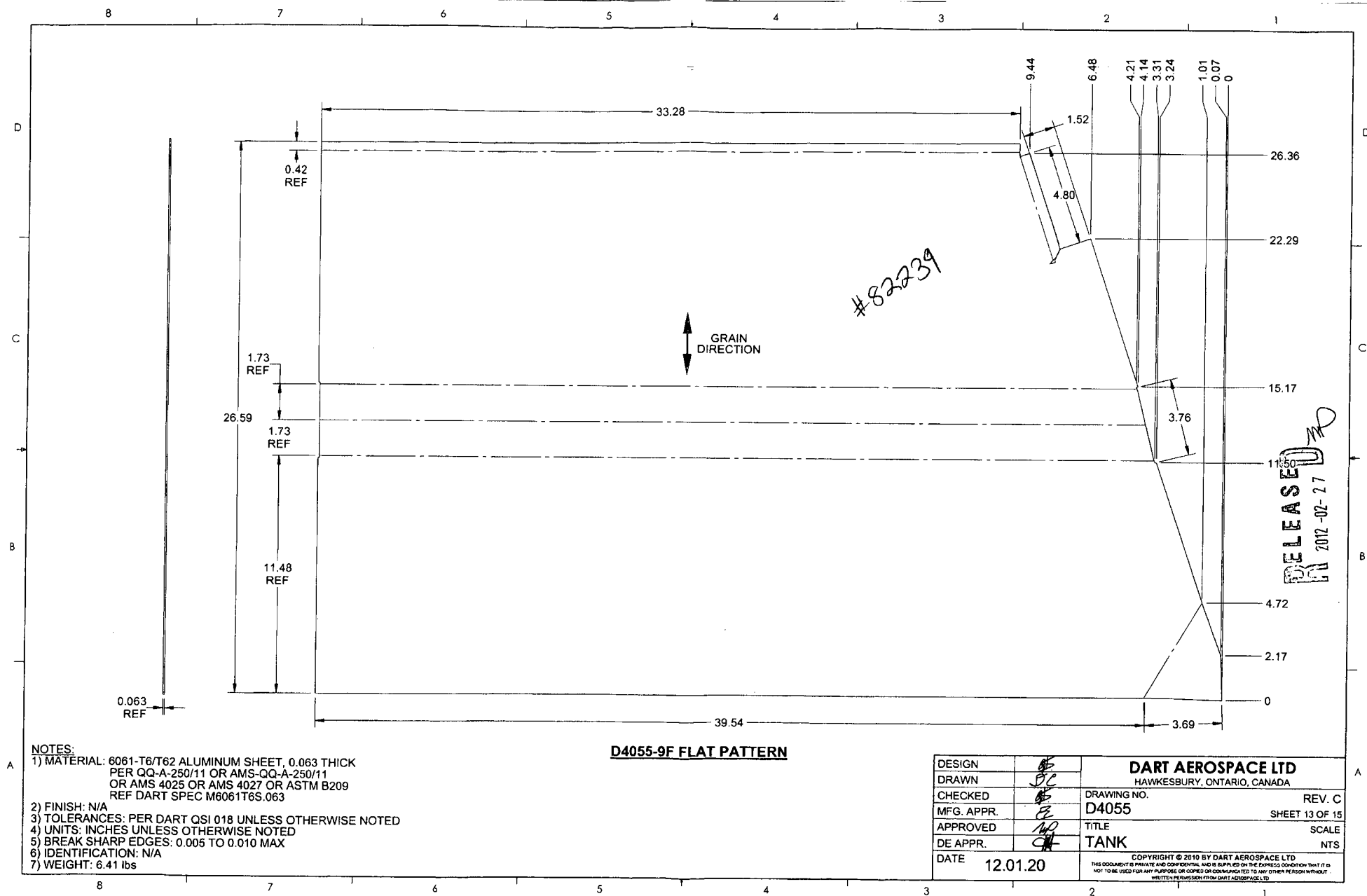
D4055-9 TANK BACK

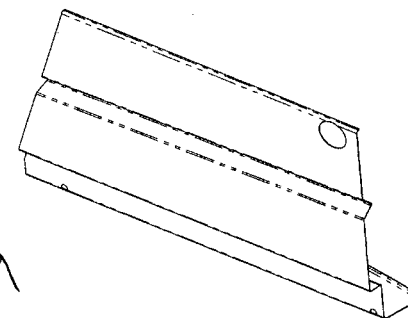
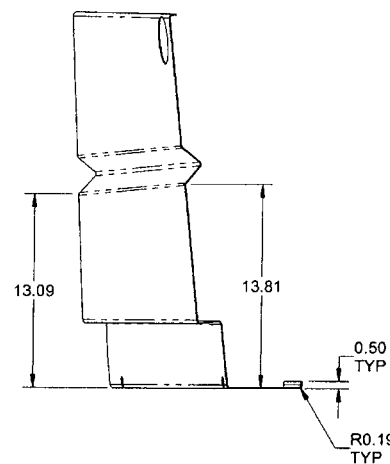
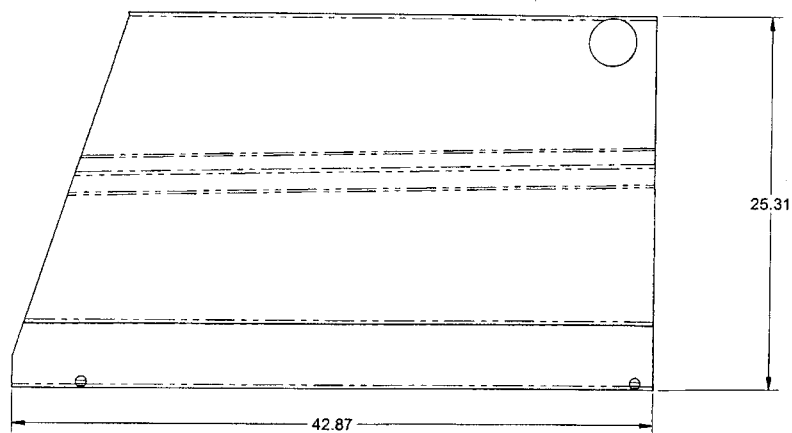
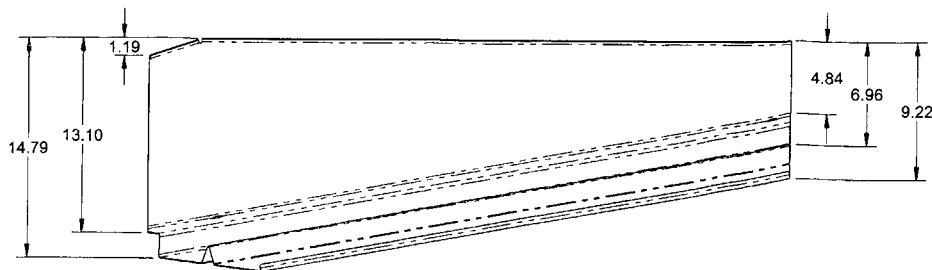
NOTES:

- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

DESIGN	BE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO. D4055	REV. C
MFG. APPR.	EE	SHEET 12 OF 15	
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	TANK	NTS
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2012-02-27





#82239

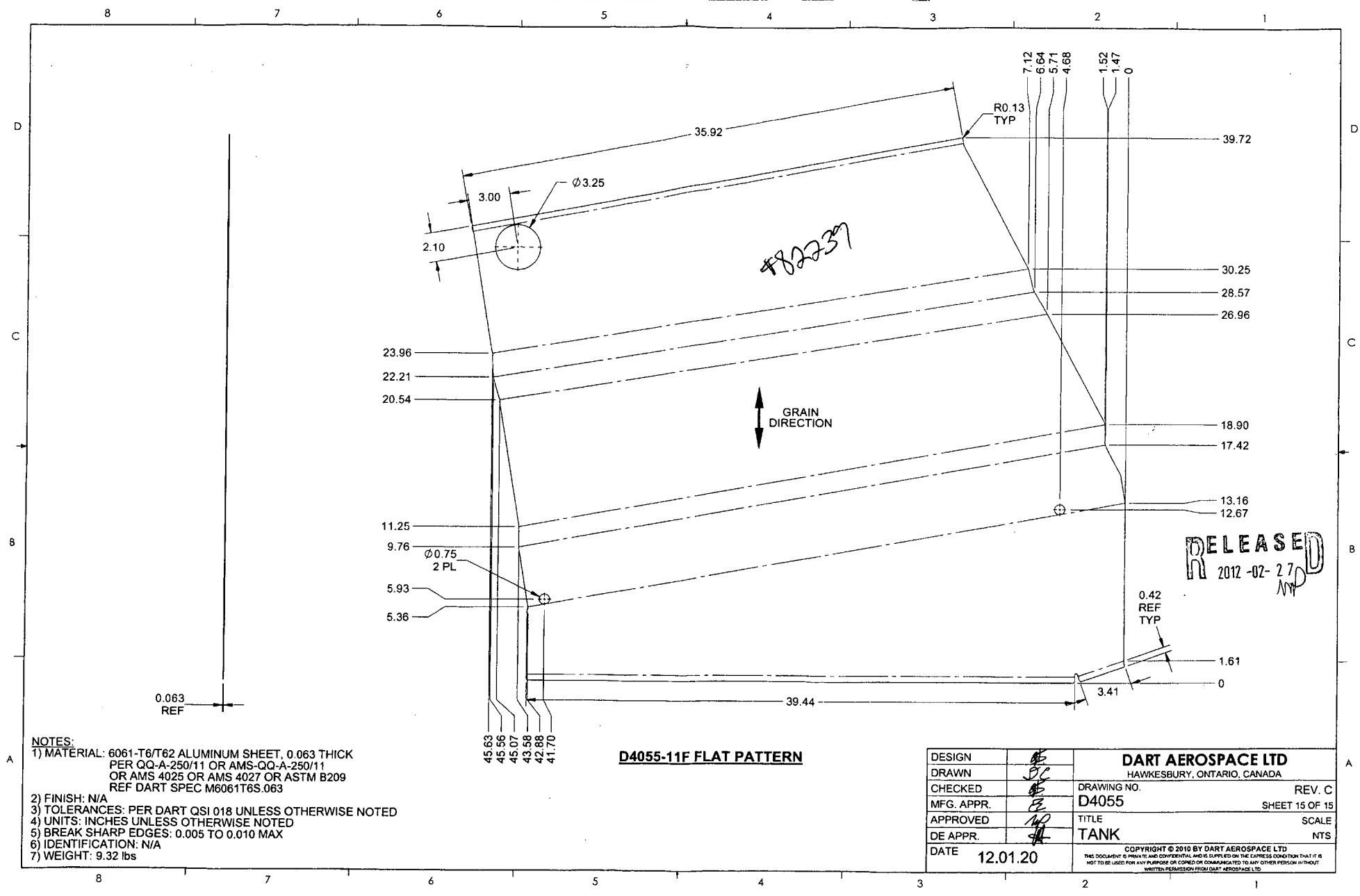
D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4055	SHEET 14 OF 15
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK	NTS
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RELEASED
2012-02-27
MD



- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs

D4055-11F FLAT PATTERN

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 15 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
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